



SCALE 4=1

1. WELD PREP IN ACCORDANCE WITH MATERIAL THICKNESS.
2. ALL WELDS MUST BE VACUUM TIGHT. NO LEAK SHALL BE DETECTABLE ON THE MOST SENSITIVE SCALE OF A HELIUM LEAK DETECTOR, WITH A MIN. SENSITIVITY OF 10^{-10} ATM CC/SEC OR BETTER.
4. CHEMICAL CLEAN FINISHED PRODUCTS:
 - a. ALKALINE CLEAN
 - b. ELECTROPOLISH (ENSURE PROTECTION FOR KNIFE EDGES)
 - c. RINSE IN DE-IONIZED WATER.
5. ALL WELDS TO BE PERFORMED IN A CLEAN ROOM CONDITION.
6. WHEN BRAZING PART #310401-00019 MUST BE FIXTURED DURING BRAZING.

3	31040101-130001	HOUSING, CUP	SEE DRAWING	1
2	310401-00019	TUBING, PROBE HOUSING	SEE DRAWING	1
1	310401-00021	FLANGE, SPECIAL	SEE DRAWING	1
ITEM	DWG. & ELECTRONIC FILE No.	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

UNLESS OTHERWISE SPECIFIED:
ALL DIMENSIONS ARE IN INCHES

TOLERANCES		
DECIMALS		ANGULAR
.X	$\pm .015$	$\pm .25^\circ$
.XX	$\pm .010$	
.XXX	$\pm .005$	

SURFACE ROUGHNESS 250 ✓

REMOVE ALL BURRS AND
BREAK SHARP EDGES .03 MAX.

SURFACE TEXTURE TO BE IN
ACCORDANCE WITH LATEST ANSI B46.1

DIMENSIONING & TOLERANCING IN
ACCORDANCE WITH LATEST ANSI Y14.5

[illegible]

DO NOT SCALE DRAWING

ELECTRONIC FILE NUMBER

A07609

DRAWN BY

ED. GARCIA

ED: SAROIA
CHECKED BY

RESPONSIBLE ENGINEER

7	
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5

MATERIAL	
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SEE B.O.

SEE B.U.

2

THIS DRAWING IS THE PROPERTY OF
ARGONNE NATIONAL LABORATORY

	DATE
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[illegible]

	DATE
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BASED	DATE
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1

$1 = 1$	SIZE
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[illegible]

1 of 1

THIS DRAWING IS THE PROPERTY OF

TITLE	ADVANCED PHOTON SOURCE R.F. CAVITY FIELD PROBE
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HOUSING, SUBASSEMBLY

HOUSING, SUBASSEMBLY
DRAWING NUMBER

DRAWING NUMBER		
31040101	130100	00

31040101-130100-00

$$\frac{51040101}{1} = 130100 = 00$$